

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024527**Date Inspected:** 22-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Steve Jensen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) North Tower field splice welding
- 2) East Tower field splice fit-up

1)The QAI observed ABF personnel welding field splice closure plates inside the North tower shaft at field splice #3. The QAI observed Xiao Jian Wan, ID 9677, at the North upper plate (weld N165) and Salvador Sandoval, ID 2202, at the North-East upper plate (weld NE165). The QAI noted that both welders are making vertical fillet welds (3F) using self shielded flux cored arc welding (FCAW-S) with 1.8mm diameter E71T-8-H16 electrode (NR-232). The QAI observed that Quality Control Inspector (QCI) Steve Jensen is monitoring this welding. The QAI was informed that welding procedure specification ABF-WPS-D15-F2200-3 is being used for this welding. The QAI randomly measured the preheat, interpass temperature and welding parameters, with the exception of travel speed, and noted that they appeared to be conforming to the WPS requirements. The QAI was present when the QCI performed a preliminary visual inspection of completed welds. The QAI noted that the QCI informed the welders that the welds were not visually acceptable. The QAI noted that this welding was in progress at the end of the shift.

2) The QAI observed ABF personnel preparing and fitting up the field splice closure plates inside the East tower shaft at field splice #3. The QAI observed Mike Jininez, ID 4671, using chain hoists and temporary attachments to

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install and fit-up the closure plates. The QAI noted that the temporary attachments are welded using shielded metal arc welding (SMAW) with E7018-H4R electrodes. The QAI was informed that ABF-WPS-D15-1200A-4 is the WPS being utilized for this work. The QAI noted that the QCI Steve Jensen is monitoring this work. At the time of the QAI's observations, there was no welding in progress and no welding parameters were verified. The QCI informed the QAI that final fit-up is ready to be measured and additional tack welding will take place. This work was in progress at the end of the shift.

Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed general observations and status of work to the QAI Danny Reyes and the QAI Lead Bill Levell. Except as described above, there were no other notable conversations or observations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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| Inspected By: | Croff, Scott | Quality Assurance Inspector |
| Reviewed By: | Levell, Bill | QA Reviewer |
